

Date: Tuesday, 14/10/2008 3:40:02 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42598
Estimate Number : 10973
P.O. Number :
This Issue : 14/10/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : CROSSTUBES
Previous Run : 42597
Written By :
Checked & Approved By : JUD 08.10.14
Part Number : D206667203
Drawing Number : D206-667-243 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 30/10/2008 Qty: 1 Um: Each

Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM
Est Rev:G 08-06-03 update as per DS19415 (ECN1198) DD
verified by:ec
Est Rev:H 08-07-18 remove thread masking in step 12 DD
verified by:EC

Additional Product

Job Number



Seq. #

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



JUD 08.10.20



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0

D206667203TRN

Crosstube Turning Detail



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-42591

DP/MS 08-10-28

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

DP/MS 08-10-28

4.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

SOS 6/26 20

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

DP/MS 08/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 3:40:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42598

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff (Donot engrave on outside of tube)

MB/AD
08-10-29

AWM
MB 08-10-30

MB/AD
08-10-29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-10-30



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/10/31 (80)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/31 (80)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 7504

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 208111/03 ①

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42598

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Inspect work to current step & ensure results are as per Dwg D206-667-243

12.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 08 14 -03

13.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 08 11 04

①

14.0 D2873045 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

38316

RT 08 14 -03

15.0 D2873043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

37769^{x1}/40218

RT 08 11 -03

16.0 MS20601AD4W10 RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

108673

RT 08 11 -03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42598

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

0.53 RT 06.11.10

RT 08-11-03

18.0

D3595075450

D3595063450

RUBBER CUSHION .75" x 4.50



RT 06.11.10



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
RUBBER CUSHION .75" x 4.50

64222/4/108 RT 08-11-04

19.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

35581

RT 08-11-04

20.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

107356

RT 08-11-04

21.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

SEE DSI 9415

1-Install abrasion strips as per QSI-035 using DT8580. Note: (3) top holes should be facing up.

MARGARIDA 6398

BIN 108966 RT 08-11-04

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 08-11-04

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42598

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description:

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

24.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: M107013 x 3 M109001 x1

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut
Batch: M108827

26.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick: Packing Kit
Qty Part number Description Batch
10 AN5-10A Bolt M108990

27.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Pick: Packing Kit
Qty Part number Description Batch
4 AN5-32A Bolt M09068

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Pick: Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer 109059

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42598

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



08-11-11 (1)

Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



(15)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: 63

PPP Rev: 8 July

SD

31.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

D206 667 203 B42598

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

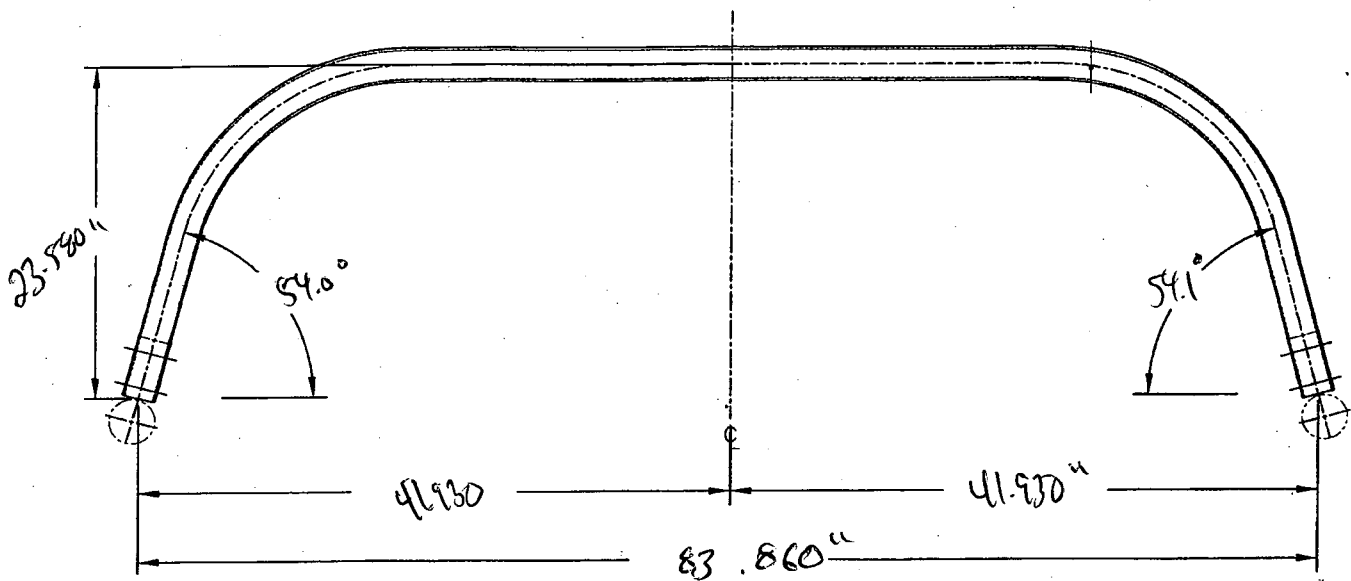
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42598
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	08/06/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26**UNDER REVIEW**

06.08.10/RH

re-drawn Detail F

P 02.10.15

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

P 02.10.15
752519415
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WITHOUT NOTICE
WORK ORDER
NO. 42598

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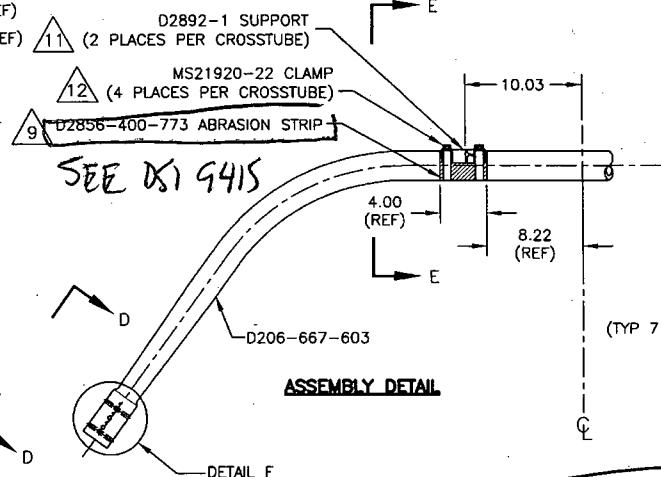
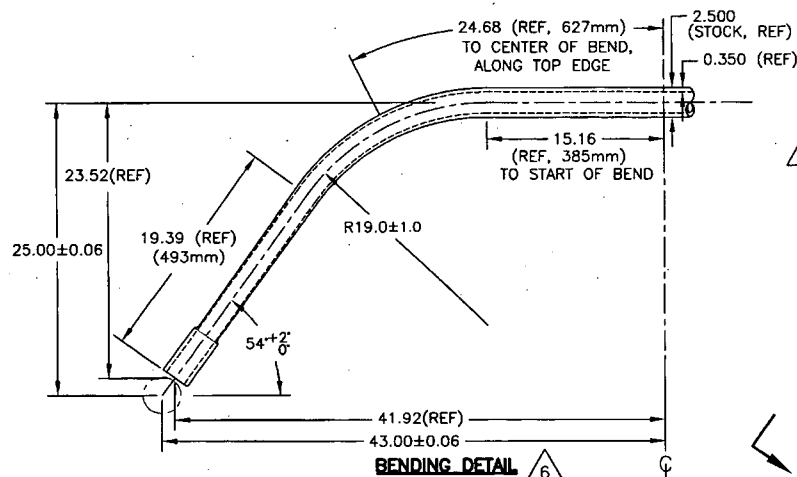
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NOTE: Date & initial all entries



B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

DETAIL F
SCALE 2:5

MS21920-22 CLAMP (REF)
D2892-1 SUPPORT (REF)

SECTION E-E
SCALE 2:5

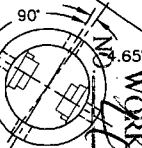
D2856-400-773 ABRASION STRIP (REF) 0.13 (REF)

D2873-043
NUT PLATE (1)
MS20601AD4W10 RIVET (4)
(1 PLACE PER CUFF)

FLW

2.500±0.005

0.780
0.500



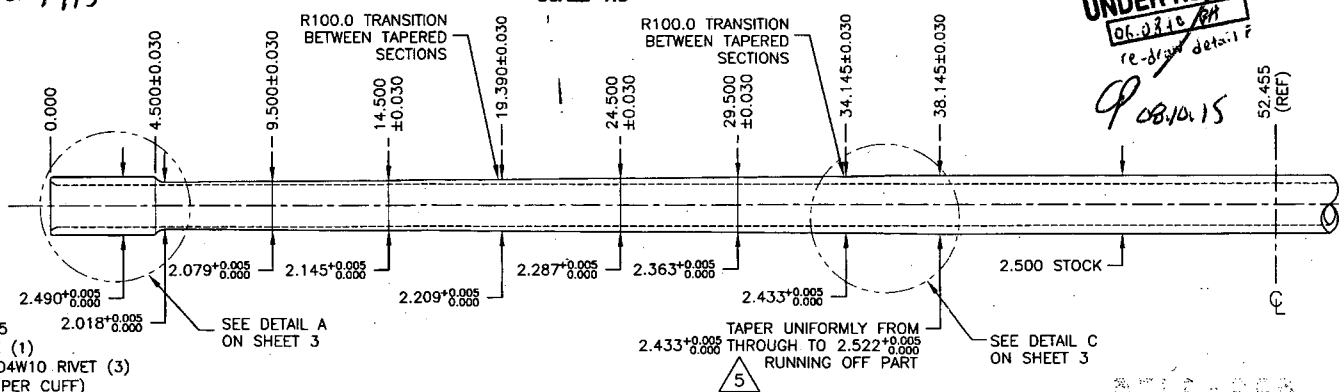
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WORK ORDER
110548

VIEW D-D:
CUFF DETAIL
SCALE 2:5
RETURN TO
ENGINEERING

D2873-045
NUT PLATE (1)
MS20601AD4W10 RIVET (3)
(1 PLACE PER CUFF)

$\phi 0.323^{+0.005}_{-0.000}$
HOLE TO BE ALIGNED
WITHIN ± 0.001 OF HOLE
ON OTHER SIDE OF CUFF

TURNING DETAIL
SCALE 1:5



UNDER REVIEW
06.08.15 PH
re-draw detail F
08.10.15

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DESIGN	PH
CHECKED	APPROVED
DATE	

DRAWN BY	PH
DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DRAWING NO.	REV. B
D206-667-243	SHEET 2 OF 3
TITLE	SCALE
CROSSTUBE ASS'Y (206L HIGH AFT)	1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

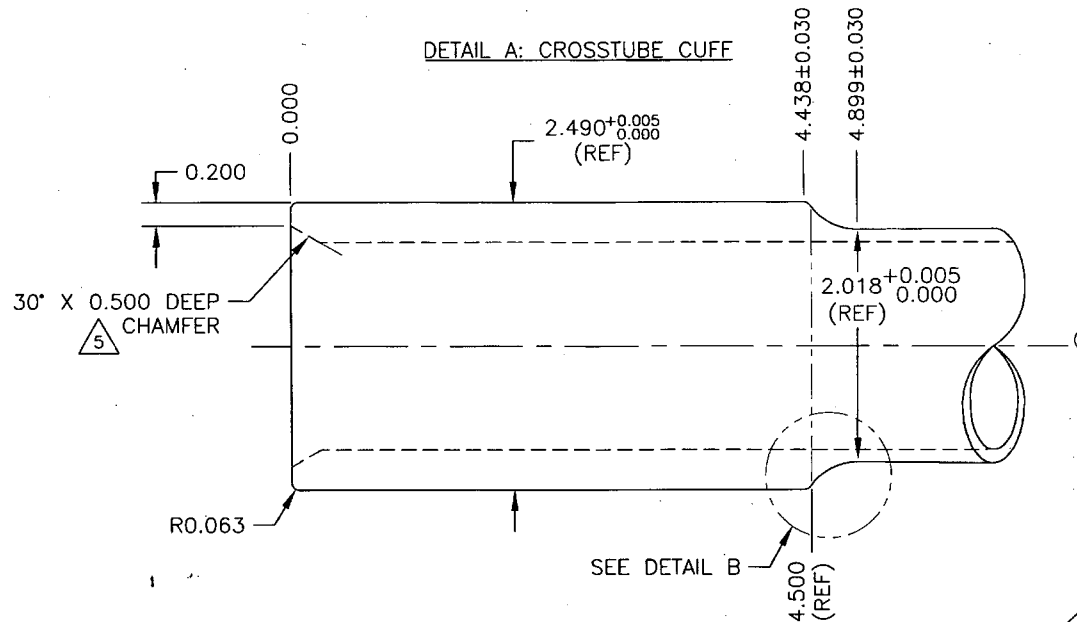
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DETAIL A: CROSSTUBE CUFF

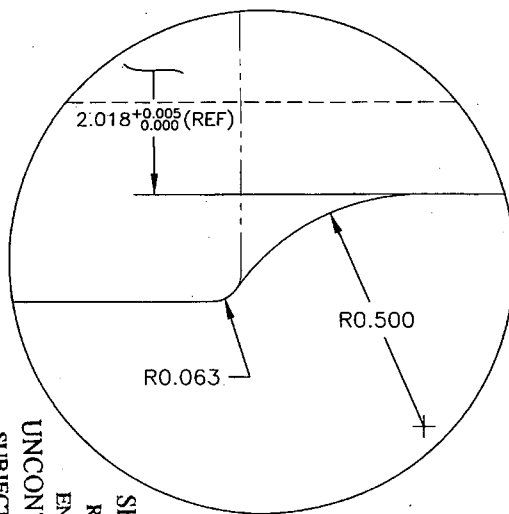


UNDER REVIEW

06.03.10 PH

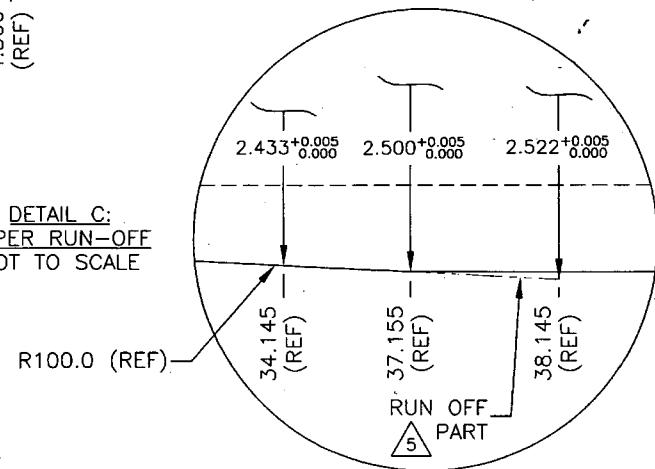
re-run detail if

06.10.15



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26	SCALE	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1

NO. 49518

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2
REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

For D206-667-101/-201/-103/-203 or D407-667-105 cross tubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-075-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-075-395	RUBBER CUSHION
25				4		D3595-075-450	RUBBER CUSHION

-063 # 06.11.10

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 41055 Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-075-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	EE	DSI 9415	SHEET 1 OF 2
APPROVED	WFO	TITLE	SCALE
DE APPR.	HA	CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-075-395	RUBBER CUSHION
	4	D3595-075-450	RUBBER CUSHION

CROSSTUBE
D206-667-101
D206-667-201
D206-667-103
D206-667-203
D407-667-105
REF

D2891-1 OR D2892-1
SUPPORT

CROSSTUBE
D206-667-101
D206-667-201
D206-667-103
D206-667-203
D407-667-105
REF

MS21920-20/-22
CLAMP

MAGNABOND 6398 BETWEEN D2891-1/D2892-1
SUPPORT AND CROSSTUBE

D3595-075-395/-450 RUBBER CUSHION
(REF) (2 PLACES)

SECTION A-A

PART NUMBER	DISTANCE "X"
D206-667-101	13.08"
D206-667-201	13.08"
D206-667-103	13.08"
D206-667-203	10.03"
D407-667-105	13.08"

FIGURE 1 - CROSSTUBE SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK UNDER
NO 42598

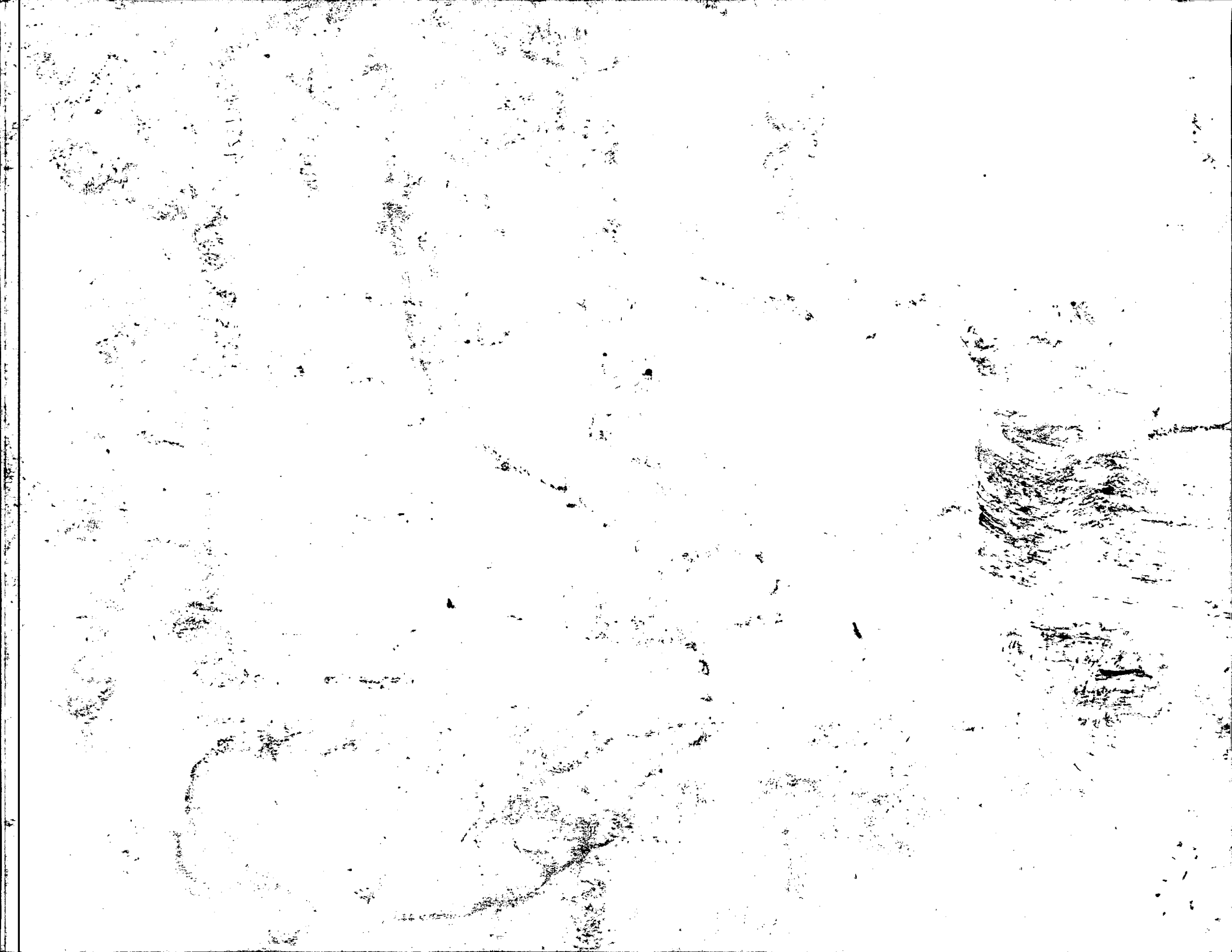
CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>PH</i>	DRAWING NO. DSI 9415	REV. A
MFG. APPR.	<i>EZ</i>	SHEET 2 OF 2	
APPROVED	<i>PH</i>	TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
DE APPR.	<i>PH</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.05.26		



P- 09130